

Date: Wednesday, 10/12/2008 3:12:22 PM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : COVER PLATE ASSEMBLY, LH |
| Job Number | : 43970 | | |
| Estimate Number | : 12301 | | |
| P.O. Number | : | Part Number | : D3467047 |
| This Issue | : 10/12/2008 S.O. No. : | Drawing Number | : D3467 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 1 / Type : SMALL /MED FAB | Drawing Revision | : B |
| Previous Run | : 36097 | Material | : |
| Written By | : | Due Date | : 12/12/2008 Qty: 1 Um: Each |
| Checked & Approved By | : <u>MF 08-12-12</u> | | |
| Comment | : Est Rev: A New Issue 06-04-24 EC Est Rev: B As per Rev B 06-05-24 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|----------------|
| 1.0 | D34671 | Cover Plate LH |
|-----|--------|----------------|



(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3467-1 Shourd Plate

Seal Strip

| | | |
|-----|--------|------------|
| 2.0 | D34677 | Seal Strip |
|-----|--------|------------|



(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3467-7 Doubler

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



(1X)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-047

| | | |
|-----|------|-----------------------------------|
| 4.0 | QC11 | VISUAL INSPECTION OF SPOT WELDING |
|-----|------|-----------------------------------|



Comment: VISUAL INSPECTION OF SPOT WELDING

SIS 02/11/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 10/12/2008 3:12:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE ASSEMBLY, LH

Job Number: 43970

Part Number: D3467047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/11/18

①

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SB 09/11/18

①

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/11/30

Job Completion



U 09.11.30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

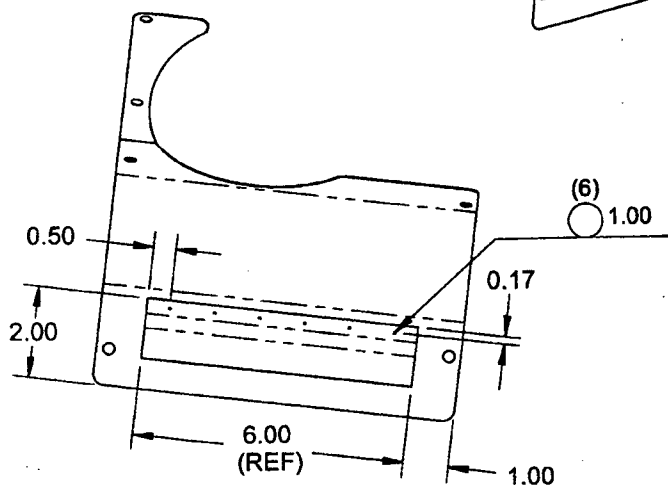
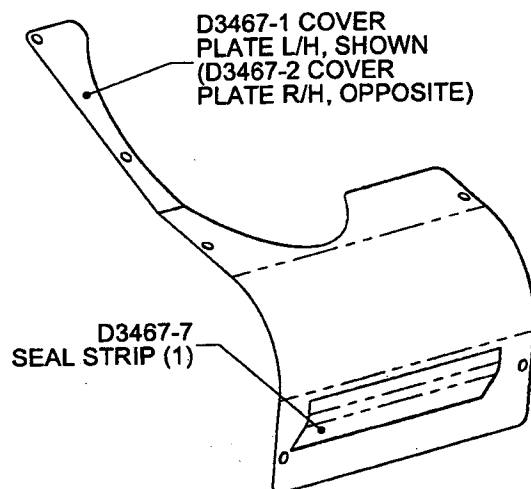
NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|---------------|--|-------------------------|
| DESIGN B | DRAWN BY B | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3467 | REV. B SHEET 4 OF 15 |
| DATE 06.05.15 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |

RELEASED
06.05.15**UNDER REVIEW**

C2.04.02.1

Dipl. & plan. d'act. techn.
(Chantel)

43970

30°
(REF)**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY -047 | QTY -048 | P/N | DESCRIPTION |
|-------------|-------------|-----------|---------------------------|
| X | | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| | X | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1 | | D3467-1 | COVER PLATE, L/H |
| | 1 | D3467-2 | COVER PLATE, R/H |
| 1 | 1 | D3467-7 | SEAL STRIP |

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 70

EMPLOYEE: Marc Bragery

PART NUMBER: D 3467 047

JOB NUMBER: 43970

MATERIAL TYPE: 304

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium SS

TEST RESULTS

| | PASS | FAIL |
|----------------|--------------|------|
| VISUAL: | [<u>/</u>] | [] |
| PENETRATION: | [<u>/</u>] | [] |
| PULL STRENGTH: | [<u>/</u>] | [] |

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 09/16/17
QUALIFIER: SB